

Work Order ID 146786

Thursday, May 26, 2016 8:09:32 AM

146786

Page 1

Item ID: D4895-047

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Outboard Beam Assembly

Start Date: 5/24/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 6/3/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4895

B

100

0.00

100

Waterjet

Memo

3.44

FLOW CNC Waterjet

CUT BLANK AS PER FILE D4895-7_BLANK

(4) ϕ 2x 16 / 08 / 02

110

0.13

110

HAAS 4

Memo

3.28

HAAS CNC vertical machine #4

MILL AS PER FOLIO FB330 AND DWG D4895

FOLIO REV: 11DWG REV: B

DEBURR

4 ϕ DAS 33 9-80 17/01/08

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[illegible]

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N900040100

Setup Start

NS1

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4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC7-Inspect Chemical Conversion Coat

0.00

170

QC

Memo

0.04

Quality Control

4 0 17-01-20 34 9-89

171

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

171

Powdercoat

Memo

0.56

Powder Coating

MASK HOLES AS PER NOTE 8

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:25
320°
9:55

4 0 17-01-20 33 9-89

172

QC3- Inspect Part Finish

0.00

172

QC

Memo

0.04

Quality Control

4 0 17-01-20 38 9-89

JAN 20 2017

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[illegible]

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Page 5

Item ID: D4895-047

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Outboard Beam Assembly

Start Date: 5/24/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 6/3/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC21 - Final Inspection - Work Order Release	0.00							
210							DAS 21 9-89	FEB 03 2017	
QC	Memo	0.40							
Quality Control									

DAS
21
9-89 FEB 03 2017

Picklist Print

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Page 1

Work Order ID: 146786

146786

Parent Item: D4895-047

D4895-047

Parent Item Name: Aft Outboard Beam Assembly

Start Date: 5/24/2016

Required Date: 6/3/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IIP REV:A 14.07.25 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4859-1

Manufactured

No

Each

20.0000

16

D4859-1

FF

JAN 23 2017
JAN 7

Bushing

Location

Loc Qty

Loc Code

ST130

20

124826

1

137183

19

M6061T6B1.000X12.00
0

Purchased

No

f

48.0000

12.04

M6061T6B1 000X12 000

Dec 16/08/02

6061-T6 Bar 1.00 x 12.00

Location

Loc Qty

Loc Code

MAT

48

m133265

24

m134705

24

9

DART AEROSPACE LTD		Work Order:	146786
Description: Aft Outboard Beam		Part Number:	D4895-7
Inspection Dwg: D4895 Rev: B		Page 1 of 1	

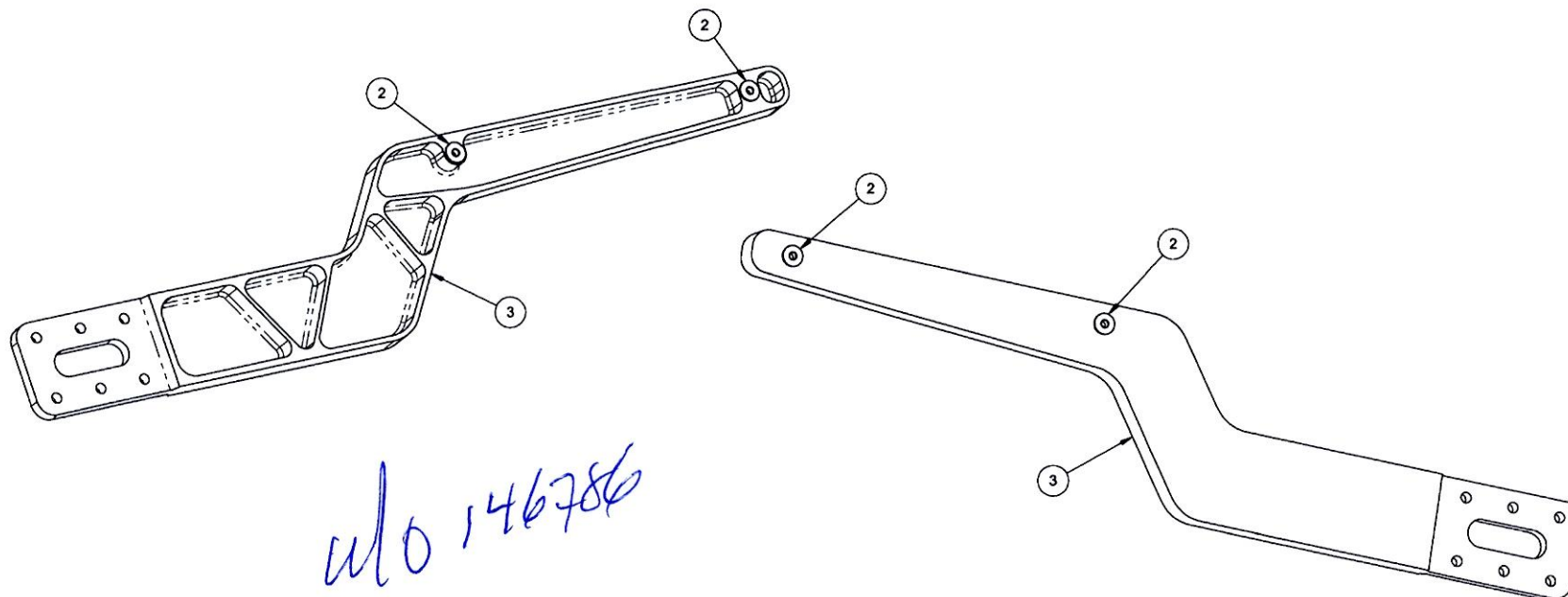
FIRST ARTICLE INSPECTION CHECKLIST

	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
CNC Milling	32.55	+/-0.030	32.550	✓		HJP-07	Tape
	R1.50	+/-0.030	1.500	✓		HJP-04	vern
	R0.38	+/-0.030	0.380	✓		...	...
	4.63	+/-0.030	4.630	✓			
	5.75	+/-0.030	5.747	✓			
	0.250	+/-0.010	0.250	✓			
	0.150	+/-0.010	0.150	✓			
	3.00	+/-0.030	3.000	✓			
	R0.43	+/-0.030	0.430	✓			
	0.200	+/-0.010	0.198	✓			
	0.750	+/-0.010	0.752	✓			
	Ø0.425	+0.000/-0.002	0.424	✓			
	6.97	+/-0.030	6.972	✓			
	0.93	+/-0.030	0.930	✓			
	0.85	+/-0.030	0.850	✓			
	1.00	+/-0.030	0.991	✓			
	R0.13	+/-0.030	0.130	✓			
	0.150	+/-0.010	0.155	✓			
	Ø0.377	+0.006/-0.001	0.380	✓			
	3.00	+/-0.030	3.000	✓			
	1.15	+/-0.030	1.150	✓			
	Ø1.00	+/-0.030	1.000	✓			
	2.300	+/-0.005	2.300	✓			
	0.60	+/-0.030	0.602	✓			
	0.80	+/-0.030	0.801	✓			
	3.600	+/-0.005	3.600	✓			
	1.800	+/-0.005	1.800	✓			
	1.75	+/-0.030	1.750	✓			
	3.50	+/-0.030	3.500	✓			
Manual Mill	0.25	+/-0.030	0.245	✓			
	5.50	+/-0.030	5.500	✓			
	12.000	+/-0.005	12.000	✓			
	1.55	+/-0.030	1.555	✓			
	Ø0.465 X 90°	+/-0.010 x 0.5°	0.465 X 90°	✓			
	R0.25	+/-0.030	0.250	✓			
	0.500	+/-0.010	0.504	✓			

Measured by:	33 9-89	Audited by:	DAS 08 9-89	Preliminary Approval:	
Date:	17/01/02	Date:	17-01-10	Date:	

Rev	Date	Change	Revised by	Approved
A	14.08.05	New Issue	KJ	

ITEM	QTY -047	P/N	DESCRIPTION
1	X	D4895-047	AFT OUTBOARD BEAM ASSY
2	4	D4859-1	BUSHING
3	1	D4895-7	AFT OUTBOARD BEAM



D4895-047 AFT OUTBOARD BEAM ASSY

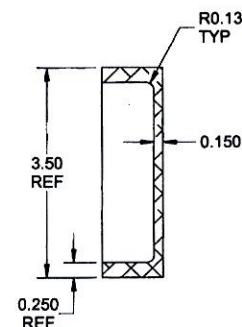
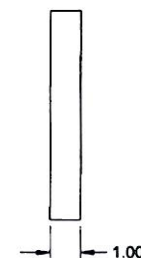
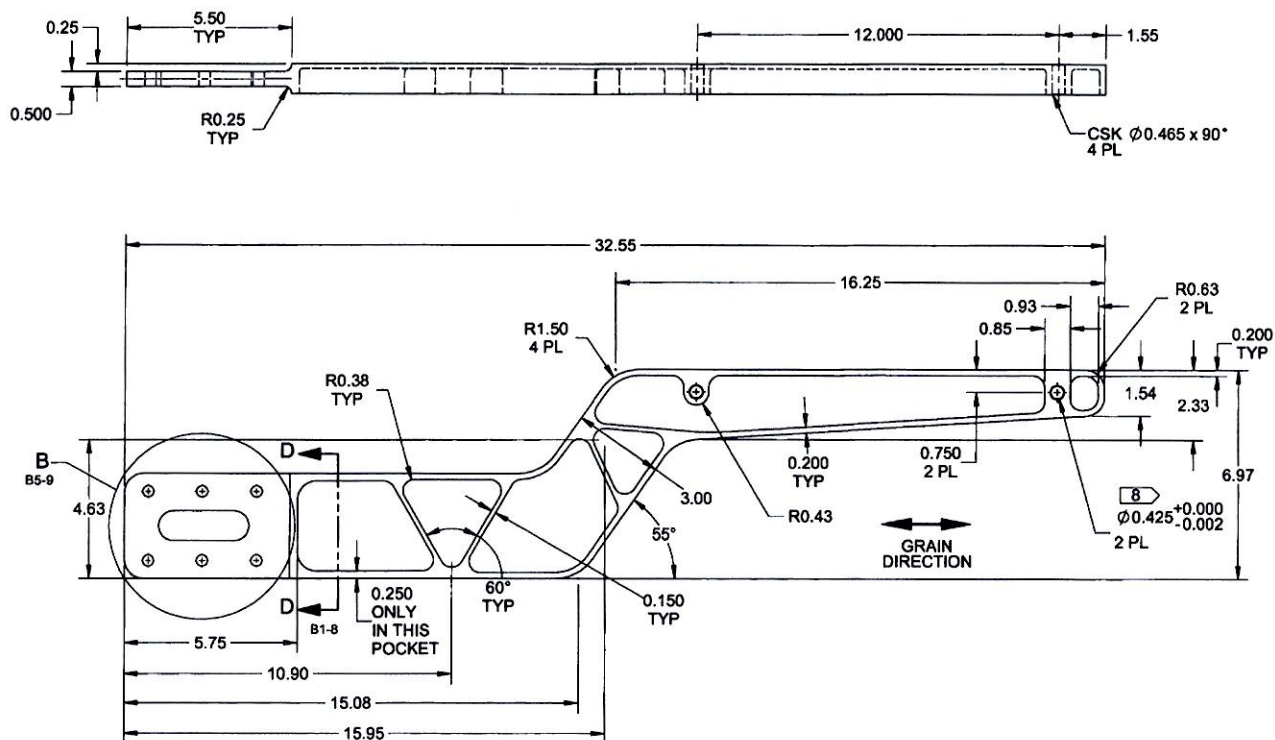
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 3.44 lbs
- 8) PRESS FIT D4859-1 INTO D4895-7. IT IS ACCEPTABLE USE MAGNABOND ADHESIVE, REMOVE EXCESS ADHESIVE FROM BUSHING HOLE

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	JLM	D4895	SHEET 4 OF 9
APPROVED	HS	TITLE	SCALE
DE APPR.	DE	OUTBOARD BEAM	NTS
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RELEASED
2014-07-26



SECTION D-D B7-8

D4895-7 AFT OUTBOARD BEAM

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 3.39 lbs
- 8) MASK HOLES PRIOR TO POWDER COAT
- 9) UNDEFINED FEATURES CONTROLLED BY CAD FILE D4895-7.SLDPRT

u/6146786

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	JLM	D4895	SHEET 8 OF 9
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